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Sold Alone

D3391-023
Job Sheet 184421



Part No: D3391-023

Job Qty: 1 ea

Part Name: Mid Tube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/9/18

Job Tracking No:

Due Date: 11/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV J SHEET 2 and 7 IPP A 05.10.20 New Issue KJ/EC IPP B IPP C 07.03.20 rev F dwg EC IPP D 07.03.28 re-format EC IPP E 07.10.31 ecn 1053P EC IPP Rev:F ECN 1056 07-11-13 DD verified by: EC IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP Rev:J add in seq 140 expire date &b# sikaflex DD 10.02.17 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/12/18	11/12/18	0.00	0.00	Start Up Skidtubes-1		<i>J.V.</i>
100	Skidtubes	1 pcs	11/12/18	11/12/18	0.88	2.11	Skidtubes-4		<i>J.V.</i> <i>DAS</i>
110	QC	1 pcs	11/12/18	11/12/18	0.00	0.00	QC5		<i>38</i>
120	HandFinish	1 pcs	11/12/18	11/12/18	0.00	0.38	HandFinish1		<i>D.R. 18/10/17</i>
130	QC	1 pcs	11/12/18	11/12/18	0.00	0.00	QC7-2		<i>BE</i>
140	Skidtubes	1 pcs	11/12/18	11/12/18	0.00	2.11	Skidtubes-4		<i>BE</i>
150	QC	1 pcs	11/12/18	11/12/18	0.00	0.00	QC5		<i>BE</i>
160	Skidtubes	1 pcs	11/12/18	11/12/18	0.00	2.11	Skidtubes-4		<i>BE</i> <i>DAS</i> <i>J.V.</i>
170	QC	1 pcs	11/12/18	11/12/18	0.00	0.00	QC10		<i>38</i> <i>0.88</i> <i>38</i>
180	QC	1 pcs	11/12/18	11/12/18	0.00	0.00	QC5		<i>38</i>
185	HandFinish	1 pcs	11/12/18	11/12/18	0.00	0.38	HandFinish2		<i>D.R. 18/10/25</i>
191	SprayPaint	1 pcs	11/12/18	11/12/18	0.00	0.91	Spray Paint		<i>NA</i>
192	Outsource	1 pcs	11/12/18	11/12/18			ATE003-VC		<i>QC 18-10-25</i>
193	Packaging	1 pcs	11/12/18	11/12/18	0.00	0.00	Packaging2		<i>OCT 31 2018</i>
200	QC	1 pcs	11/12/18	11/12/18	0.00	0.00	QC14		<i>18-10-31</i>
230	HandFinish	1 pcs	11/12/18	11/12/18	0.00	0.38	HandFinish4		<i>18-10-31</i>
240	QC	1 pcs	11/12/18	11/12/18	0.00	0.00	QC5		<i>NOV 01 2018</i> <i>68</i>
250	Packaging	1 pcs	11/12/18	11/12/18	0.00	0.00	Packaging3-1		<i>NOV 01 2018</i> <i>9-89</i>
260	QC21-SA	1 Ea	11/12/18	11/12/18	0.00	0.00	QC21		<i>NOV 01 2018</i> <i>9-89</i>

Part Op 100 - 1-Cut tube to finish length as per Dwg D3391 2-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 holes 4-Remove .030" from Fwd indexing Ridge as per Dwg D3391 5-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391 6-Deburr, scibe batch # on aft end. 7- Locate D3391-021 in D3391-023 at 9.00" (see view F-F) 8- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previously tranfer drilled pilot holes in D3391-023/021 using drill press. ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". D3391-021
BATCH: 9- Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.375" holes with paint marker, ***DO NOT DRILL HOLES #3-19-20 FROM FWD END OF JIG*** Locating from two fwd wearplate holes in D3391-023 drill remaining 6 wearplte holes in D3391-021 using DT8937 10- Open wearplate holes of D3391-023 assembly detail section Q-Q to Ø0.375" (10 holes) as per Dwg D3391 Open wearplate holes of D3391-023 assembly detail section H-H to

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment	☐	No Re-verification	☐	Pressure/Forced	☐
Design	☐	Operator	☐	Bending	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐
Material	☐	Use for Testing	☐	Cuffs	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐
Past Expiry Date	☐	Manufacturing Process	☐	Temperature/Cure	☐
Misidentified	☐	Past Due	☐	Set-up	☐
				BOM/Route	☐
				Broken/Damage/Defect	☐
				Inspection Incomplete/Unqualified	☐
				Contamination	☐
				Countersink	☐
				Cut Too Short	☐
				Instructions Incomplete/Unclear	☐
				Drill Holes	☐
				Power Loss/Surge	☐
				Folio/Program	☐
				Grain	☐
				Weld	☐
				Wrong Stock Pulled	☐
				Out of Sequence	☐
				Off-set	☐
				Mislabeled	☐
				Fit/Function	☐
				Misaligned/off center	☐
				Positioned Wrong	☐
				Outside Dimensions	☐
				Over/Under tolerance	☐
				Part Incorrect	☐
				Part Lost/Missing	☐
				Part Moved	☐
				Drawing	☐
				Finish	☐
				Misread	☐
				Turning Sequence	☐
OTHER : _____					

Ø0.297" (20 holes) as per Dwg D3391 Deburr and blow out all chips from inside tube, scribe

140 - 1-Open float bag holes as per dwg 2-C'sink float bag holes as per dwg 3- Prepare tube for welding 4-Bond web in place as per Dwg D3391 & QSI 015. Adhere for 12 hours) A/R Sikaflex exp: M158673 batch#: Nurda 2019

NOTE:ENSURE WEB IS INSERTED IN AFT END OF TUBE

160 - 1-Weld crossbolt spacer as per dwg D3391 & QSI 004 2-grind weld flush

185 - Re-alodine

191 - PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ PAINT AS PER DWG AND

QSI005 4.2.2.4 PAINT: _____

230 - 1-Install Inserts as per Dwg

192: Outsource: P0041455

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-100	Skidtube Extrusion	1 Ea (1 ea)	90-Start up Operation	006200
D3389-1	Web	1 Ea (1 ea)	140-Skidtubes	FIG 3253
D3681-1	Spacer	5 Ea (5 ea)	160-Skidtubes	511710
ALS4-1032-130	Rivnut	20 Ea (20 ea)	230-HandFinish	5103210
D3591-1	Bushing	2 Ea (2 ea)	230-HandFinish	5004279
				8122431

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-100	1	32	0
140-Skidtubes	D3389-1	1	11	0
160-Skidtubes	D3681-1	5	257	0
230-HandFinish	ALS4-1032-130	20	12,131	0
	D3591-1	2	11	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE

Container No: S118681



Part: D3391 - 023

Job No: 181421

Serial No/batch: S118681

Revision: J

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 10/16/18

:23 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐				



